

**Work Order ID 62992**

Friday, October 15, 2010 9:44:33 AM



Page 1

Item ID: D3838-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Stop



Start Date: 10/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/21/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *H*Date: *10/10/15* Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberReject  
StampInspec.  
Stamp

Draw Nbr	Revision Nbr
D3838	Rev A

100

0.00



Large Fab

Large Fab

Memo 0.00

Large Fab

1- cut D3838-1 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

4- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open  
to finish size as per dwg D3838A/R ER316 S.S. Rod Batch: *111585*

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: *111585*

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

*SAA 10-10-18**②**GL 10.10.18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

H10-10-19

2 8



QC

Memo

0.00

140

QC5- Inspect part completeness to step on W/O

0.00

2

10/10/13



QC

Memo

0.00

150

Identify as per dwg &amp; Stock Location: CWA

0.00

SAD  
10-10-19

Packaging

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Item Name: Rib Assembly (Basket Lid, LH)

Stop



Start Date: 10/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/21/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/10/2010  
MF  
10-10-19

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# Picklist Print

Friday, October 15, 2010 9:44:37 AM

Page 1

Work Order ID: 62992



Parent Item: D3838-041



Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 10/15/2010

Required Date: 10/21/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 		Manufactured	No				Each	72.0000	1	2		<i>LPC 10-10-18</i>	

Bushing

Location	Loc Qty	Loc Code
ST084	21	
56942	21	
WA	51	
54072	9	
61379	42	

M304TS0.750W.065



304 SQ Tube .75x.75x.065W

Purchased

No

100 f 678.6362 1.0317 2.172



*SAD 10-10-18*

Location	Loc Qty	Loc Code
MAT	662.0818	
112398	0	
114482	0.0002	
115494	82.0816	
115593	580	
WA	16.554385	
114520	0.527385	
115274	16.027	

*2.172*

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8

7

6

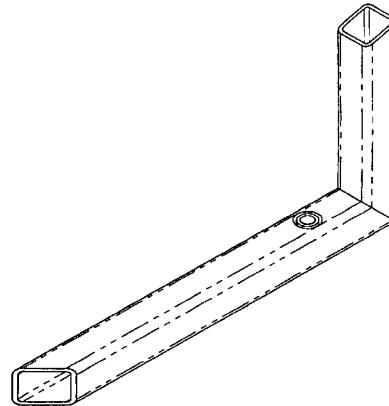
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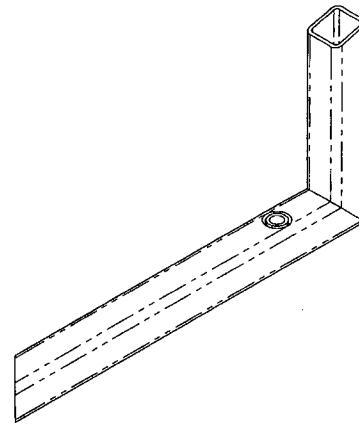
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**D3838-041 RIB ASSY (BASKET LID, LH)**



**D3838-042 RIB ASSY (BASKET LID, RH)**

**NOTES:**  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.54 lbs

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOP  
RETURN  
ENCLOSURE  
UNCONTRACTED  
SUBJECT TO  
WITH  
WORK  
NO. 42992  
B810-10-15

**RELEASED**  
 08/11/08 JMT

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AS</i>		<b>DART AEROSPACE LTD</b>
DRAWN	<i>AS</i>		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AS</i>		REV. A
MFG. APPR.	<i>AS</i>	D3838	SHEET 1 OF 3
APPROVED	<i>AS</i>		TITLE
DE APPR.	<i>AS</i>		SCALE
DATE	<b>08.10.08</b>		NTS
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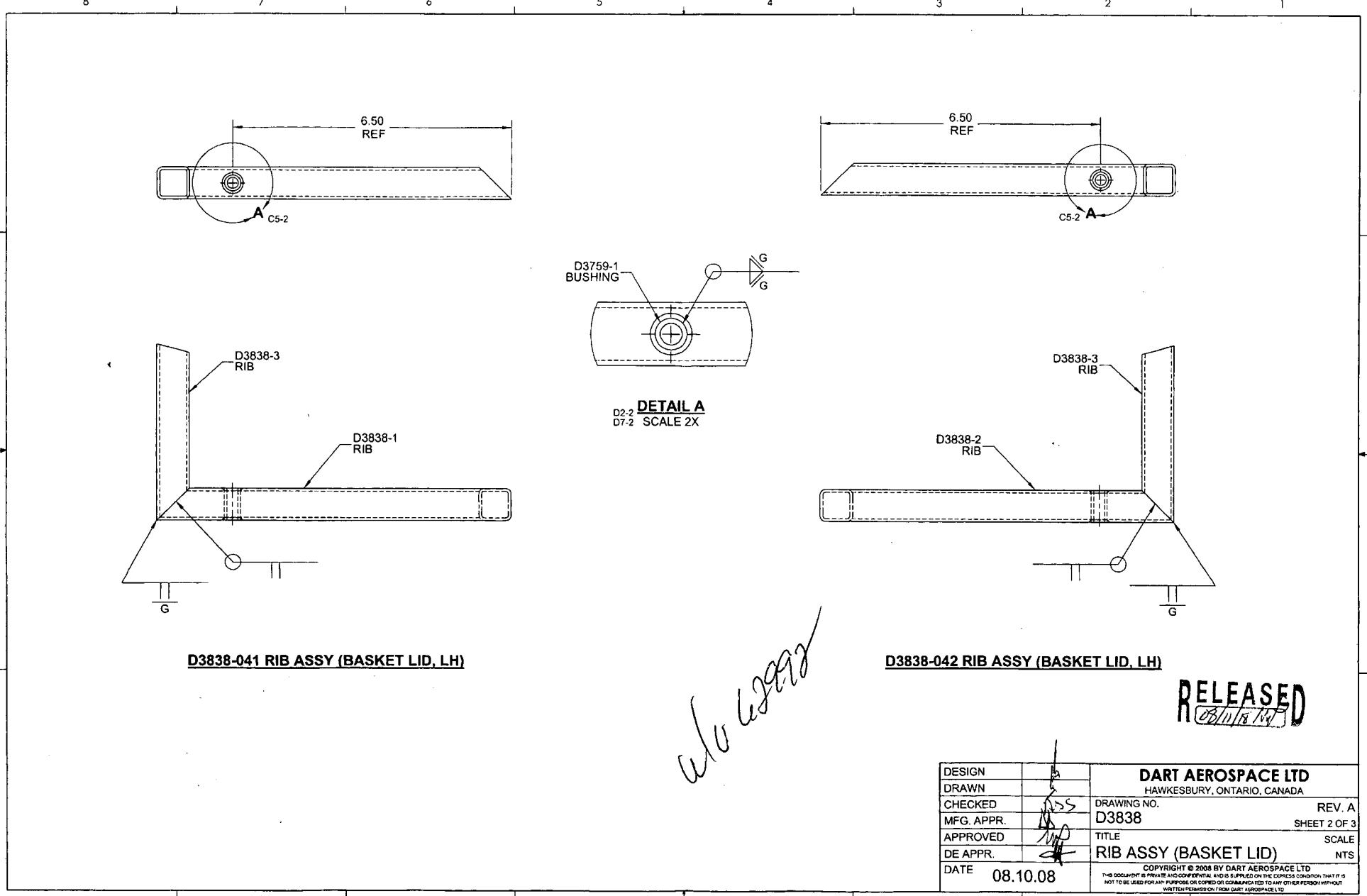
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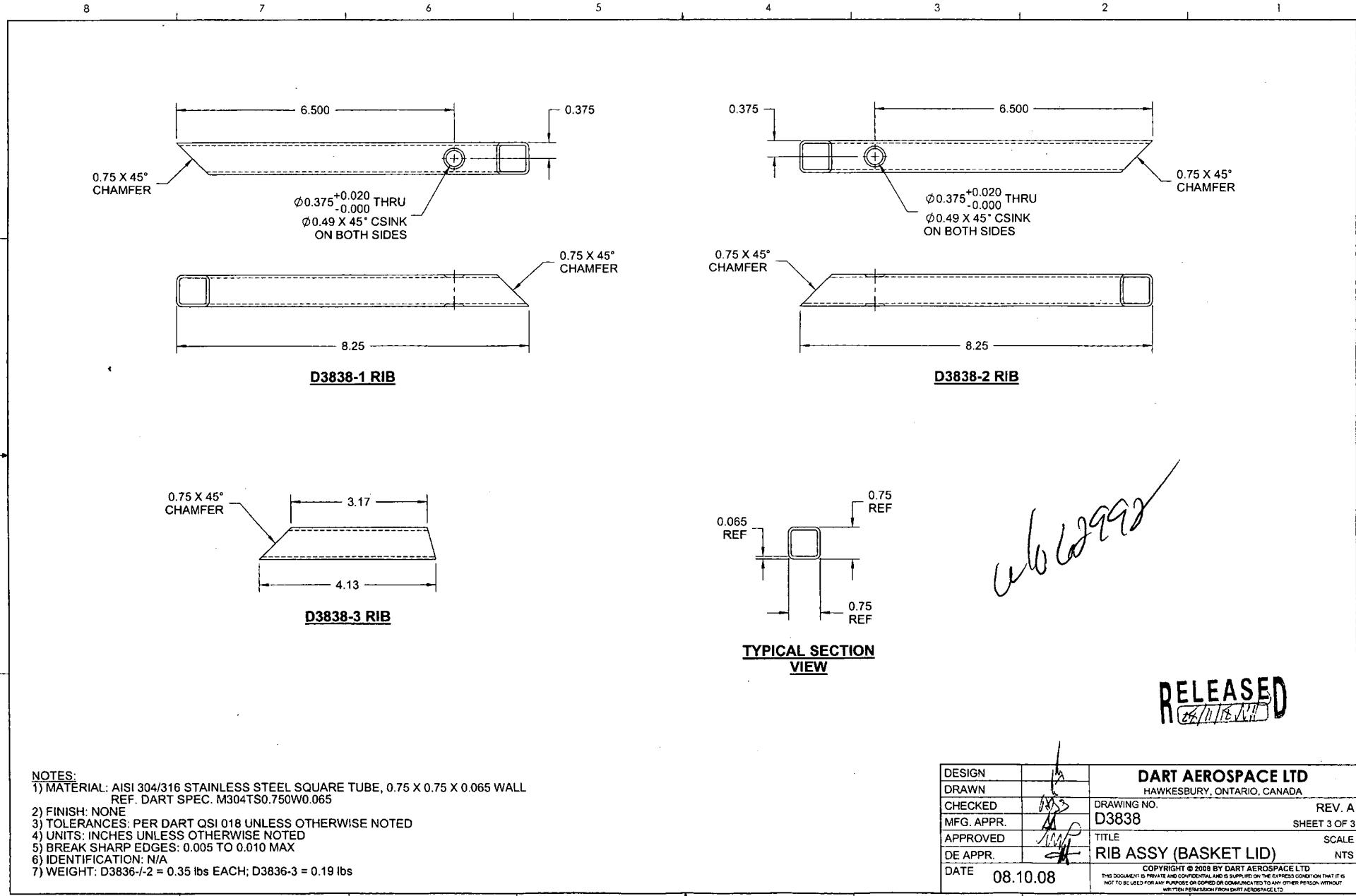
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